

Work Order ID 59451

Friday, June 04, 2010 11:25:44 AM



Page 1

Item ID:	D3264-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket					
Start Date:	6/4/2010	Start Qty:	6.00			
Required Date:	6/10/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:		Date:	10/06/04	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3264	Rev A2								

100			0.00						
Bandsaw			0.00		10/06/05	6			
Jeaspa Bandsaw									

Memo
CUT BLANK 5.700" LONG

110			0.00						
HAAS 1			0.00		10/06/06	6			
HAAS CNC vertical machine #1									

Memo
MACHINE AS PER FOILIO FA447
FOLIO REV: AA
DWG REV: A2
DEBURR AS PER DWG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Bracket

Setup Start

Stop

Start Date: 6/4/2010 Start Qty: 6.00

Required Date: 6/10/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

m. L 10/06/06

6 0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

M. A 10/06/07

6 0

6

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

= 7 m. L 10/06/07 (6x)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

START: 7:45AM

Memo Temp: 320°F

FIN: 8:15AM

0.00

=) JH 10/06/08

0.00

6/

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

6 BR 10-6-8.

170



Packaging

Packaging

Identify as per dwg & Stock Location: ST 144

0.00

Memo

0.00

6x BR 10/06/08

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Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/09 *[Signature]*

R 10-6-08

(6)

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Picklist Print

Friday, June 04, 2010 11:25:51 AM

Page 1

Work Order ID: 59451



Parent Item: D3264-1



Parent Item Name: Bracket

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP A ☐ 04.09.02 ☐ New issue ☐ KJ/JLM ☐

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No				f	30.2366	0.5	3			



6061-T6 Bar 1.25 X 4.50

Location

Loc Qty

Loc Code

MAT10

30.2366

112628

30.2366

3.0 ml 10/06/05

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DART AEROSPACE LTD		Work Order:	59451
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.687	✓			
0.063	+/-0.010	.062	✓			
0.125	+/-0.010	.125	✓			
0.875	+0.010/-0.020	.877	✓			
0.062	+/-0.010	R.062	✓			
R0.03	+/-0.030	R.030	✓			
R0.13	+/-0.030	R.125	✓			
1.00	+/-0.030	1.002	✓			
0.125	+/-0.010	.123	✓			
0.600	+/-0.010	.602	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	.750	✓			
Ø0.194	+0.005/-0.000	Ø.196	✓			
5.50	+/-0.030	5.499	✓			
0.125	+/-0.010	.125	✓			
0.063	+/-0.010	.062	✓			
R0.25	+/-0.030	R.250	✓			
4.27	+/-0.030	4.270	✓			
R0.30	+/-0.030	R.300	✓			

Measured by:	SM	Audited by:	M.A	Prototype Approval:	N/A
Date:	10/06/06	Date:	10/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	KA DD

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO

WITHOUT

WORK ORDER

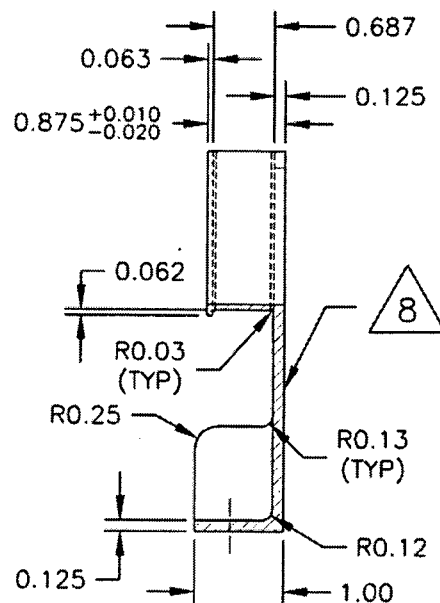
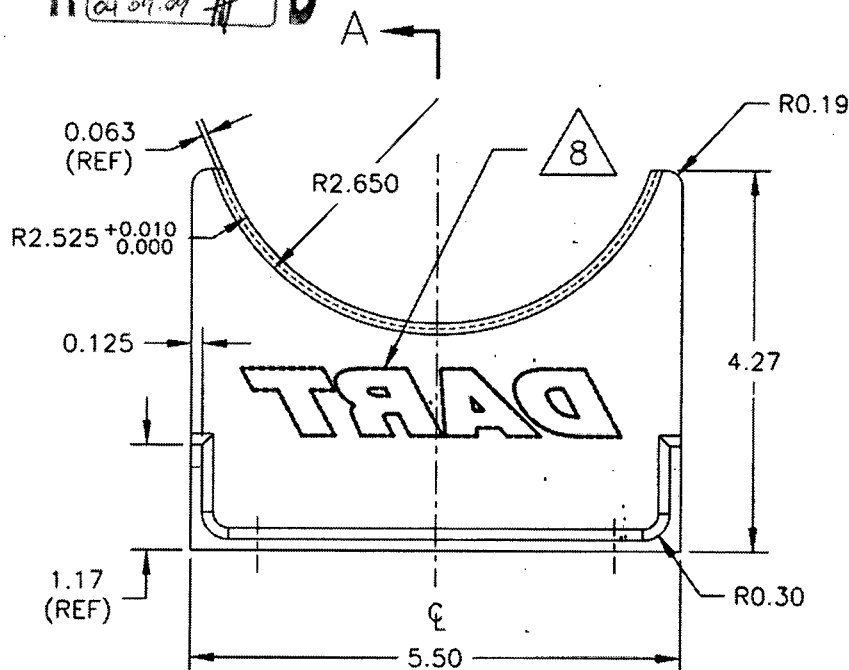
NO. 5945-1

AS10-6-04

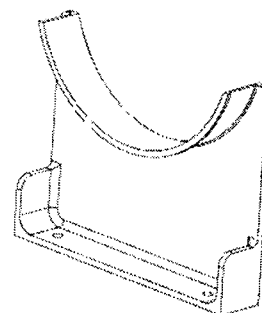
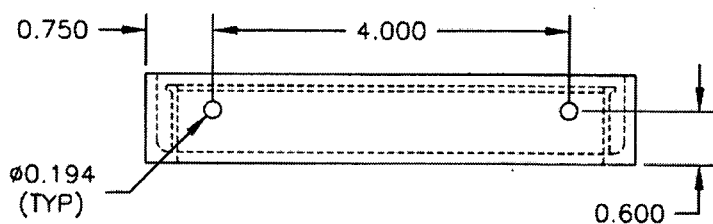
RELEASED
01 09 09 #



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75" HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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